

## ABSTRACT

An electrode group is fabricated by spirally winding a positive plate and a negative plate with a separator interposed between them is housed in a metal case. An upper opening of the metal case is hermetically sealed with a gasket. One side edge along the longitudinal direction of the negative plate projects out downward of the electrode plate and is joined to the bottom of the metal case while the side edge along the longitudinal direction of the positive plate projects out upward of the electrode group and is joined to the lower surface of a sealing plate. A metal current collector having a cap-shaped terminal for joining the positive electrode side and the lower surface of the sealing plate and for collecting current is welded to the protrusion of the positive plate.